

Work Order ID 50745

July 21, 2009 12:43:47 PM

Page 1

Item ID: D3689-1

Revision ID: B

Item Name: SLEEVE

Start Date: 7/20/09

Start Qty: 100.00

Required Date: 7/20/09

Req'd Qty: 100.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3689

Rev B

100

0.00



Doosan

DOOSAN LATHE

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA722 Rev: *AA* & Dwg D3689 Rev: *B*
2-CHECK THREAD WITH GO-NO GO GAUGE DT9450 A & B
3-Deburr per dwg D3689

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

C'sink .188" holes as per dwg D3689

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



SN 09/09/09

09-08-31

SN 09/09/09

09-08-01

SN 09/09/09

09-08-03

30.0 Full
59/10

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Item ID: D3689-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: SLEEVE

Start Date: 7/20/09

Start Qty: 100.00



Cust Item ID:

Required Date: 7/20/09

Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

AL 09.09.10 (31)

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SL 09/09/10

Quality Control

150

PURCHASING

0.00



Purchasing

Memo

0.00

09-9-17 (30)

Purchasing

Issue P/O: 10419
LPI Per ASTM 1417 LEVEL 2
Certificate of conformaty is required

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Item ID: D3689-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: SLEEVE

Start Date: 7/20/09 Start Qty: 100.00



Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Per 9/9/17 (31)

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

mt 09 09 18 (31)

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

9/9/18 (31) SP

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Item ID: D3689-1

Accept

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Start Qty: 100.00

Required Date: 7/20/09

Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/21 JF
MF 09-09-21

Picklist Print

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Page 1

Work Order ID: 50745



Parent Item: D3689-1RevB



Parent Item Name: SLEEVE

Start Date: 7/20/09

Required Date: 7/20/09

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174PH-H900R1.375		Purchased	No			100	f	64.0000	52.6316			



17-4 SS H900 ROUND BAR 1.375



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

64

110540

14

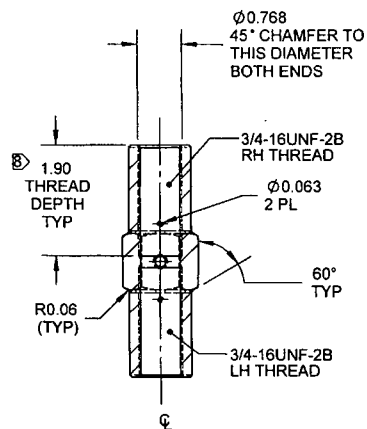
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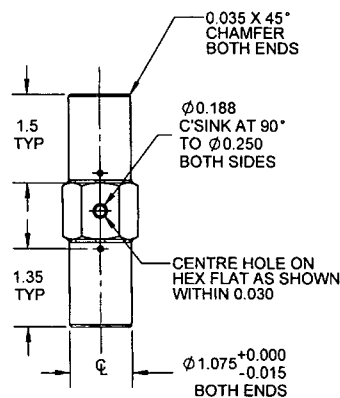
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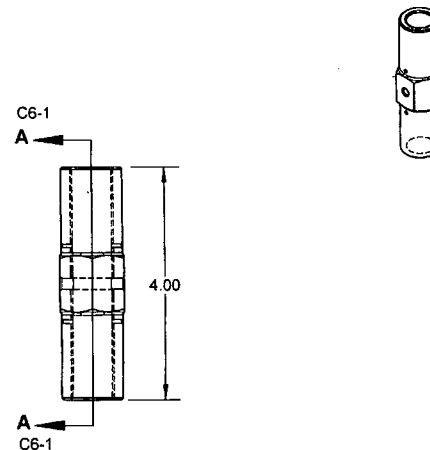
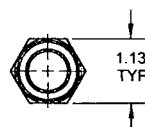
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SECTION A-A
D3-1



D3689-1 SLEEVE



W/D 50745

RELEASED
08/12/15

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.67 lb
 - 8) DIMENSION SHOWN IS MINIMUM DEPTH OF FULL THREAD
 - 9) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A8-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3689	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SLEEVE	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



LIQUID PENETRANT TEST REPORT

P- 0913

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CLIENT Dart Aerospace DATE Sept 17th 2009 TIME AM ☒ F
ATTENTION Linda Lucelle ACUREN JOB NO. 188-09-1556
ADDRESS 1270 Aberdeen St. POWO No. 10419
Hawkesbury WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417/QS1038 REV./DATE 200
PROJECT x-Tubes, on 12 studs and 31 sleeves
ITEM(S) EXAMINED Sob #'s 50745, 51772, 50984, 50985, 51877, 51880

JOB DESCRIPTION PROCEDURE No. LT-0002 REV./DATE 0212-664-101 TECHNIQUE No. LT-TECH2 REV./DATE 0212-664-101
PART NO. D3689-1, D3691-1, D412-664-203, D212-664-101 MATERIAL ALODINED ALUM. THICKNESS _____
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON
100% EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EM
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8170 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT
PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☒ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @
PENETRANT REMOVER H₂O MINIMUM DRY TIME >10 MIN. OTHER CAL # JUNE 09
DEVELOPER SKD52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE DEC
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE ON:	No indication found at or of the inspection. ACCEPTABLE TO STANDARD
31 Sleeves ID: D3689-1	✓
12 Studs ID: D3691-1	✓
2 x Crosstube Aft ID: D412-664-203	✓
2 x Crosstube Fwd ID: D412-664-101	✓

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SIGNATURES

CLIENT REPRESENTATIVE <u>C. LADORE</u>	<u>Chuck Ladore</u>	DTR #
TECHNICIAN (SIGNATURE): <u>Frederick Chagnon</u>		REPORT REVIEWED BY:
NAME (PRINT): <u>Frederick Chagnon</u>		NAME IN
CGSB LEVEL <u>IV</u> SNT LEVEL <u>IV</u>	CGSB LEVEL <u>_____</u> SNT LEVEL <u>_____</u>	
CGSB REG. No <u>10560</u>	CGSB REG. No <u>_____</u>	

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